

# Work Order ID 63845

Tuesday, November 16, 2010 1:28:58 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 11/16/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10/11/14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

H

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

*Sid 12/02*

*Hj for BG 10-12-12*

**B63845**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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Run

Start

Stop

Sequence ID/  
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DescriptionSet Up/  
Run Hours

Tool ID

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CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside  
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",  
deburr.4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade  
fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill  
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting  
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up  
holes for ground handling and detail L to 0.500" (8 holes per side)9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to  
0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB

10/11/23

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: MI15778 BE 10/11/2312-Grind welds flush as per Dwg D2750 BB 10/11/23

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 4

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1  Memo	0.00  0.00				1			BE 11/11/24
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				1			BE 10/11/24

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Page 5

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input checked="" type="checkbox"/> Skaflex-291 batch: 116040 <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> exp. date: 11-9-30								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> Aluminum Rod batch: M115778								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

BB

10/11/24

BE10/11/25

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Tuesday, November 16, 2010 1:28:58 PM

Page 6

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

8E 10/11/25

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Solubor

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Solubor

70

W/O:		WORK ORDER CHANGES					
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Page 7

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00

=&gt; M 10/11/24

1

0

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

115951

1

10-11-29

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:25

OVEN TEMPERATURE: 320

FINISH TIME: 10:55

210

QC3- Inspect Part Finish

0.00

=&gt; M 10/12/03

1

0

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
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Page 8

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220



HandFinish

Hand Finishing

HandFinishing

Memo

✓ Install inserts as per dwg D2750

0.00

⇒ M 10/12/07

0.00

1

Ø

230



HandFinish

Hand Finishing

HandFinishing

Memo

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"

batch: N/A

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M 115114

EXP DATE: 11/05

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

✓ A/R 55-o-ring lube batch: M 114189

✓ 5-Coat all exposed fasteners with "LPS Procyon"

batch: M 104596

0.00

0.00

⇒ M 10/12/07

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**Abstract**

Page 9

**Accept**

\_\_\_\_\_

**Setup Start**

**Stop**

[illegible]**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start

**Stop**

### Operation Description

## Set Up/ Run Hours

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

240

QC5- Inspect part completeness to step on W/O

0.00

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 838 839 840 841 842 843 844 845 846 847 848 849 850 851 852 853 854 855 856 857 858 859 860 861 862 863 864 865 866 867 868 869 870 871 872 873 874 875 876 877 878 879 880 881 882 883 884 885 886 887 888 889 890 891 892 893 894 895 896 897 898 899 900 901 902 903 904 905 906 907 908 909 910 911 912 913 914 915 916 917 918 919 920 921 922 923 924 925 926 927 928 929 930 931 932 933 934 935 936 937 938 939 940 941 942 943 944 945 946 947 948 949 950 951 952 953 954 955 956 957 958 959 960 961 962 963 964 965 966 967 968 969 970 971 972 973 974 975 976 977 978 979 980 981 982 983 984 985 986 987 988 989 990 991 992 993 994 995 996 997 998 999 1000 1001 1002 1003 1004 1005 1006 1007 1008 1009 1010 1011 1012 1013 1014 1015 1016 1017 1018 1019 1020 1021 1022 1023 1024 1025 1026 1027 1028 1029 1030 1031 1032 1033 1034 1035 1036 1037 1038 1039 1040 1

QC

## Memo

0.00

## Quality Control

250

## Pick Kit

0.00

### Packaging

## Memo

0.00

## Packaging

260

QC4- 100% Inspect kits for completeness

0.00

[illegible]

QC

## Memo

0.00

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Tuesday, November 16, 2010 1:28:58 PM

Page 10

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Run Start

Stop

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270



Packaging

Packaging

Packaging

Memo

Package as per PPP D350-636-012

0.00

0.00

72

MC-D

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/12/08

MF  
10-12-08

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# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Page 1

Work Order ID: 63845

Parent Item: D350-636-012

Parent Item Name: Skidtube LH



Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O  
 10.06.22 revise seq110 DD verf: EC IPP Rev: P 10.10.01 as  
 per IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225		Purchased	No			220	Each	4,520.000	38	38			
Insert													

Location Loc Qty Loc Code

PK011 4520

110768 4520

X38

AN3C5A		Purchased	No			230	Each	888.0000	34	34			
Bolt													

Location Loc Qty Loc Code

ST350 878

114330 11

115015 13

115371 100

115422 100

115594 282

115835 372

X34

ST351 10

113121 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Page 2

Work Order ID: 63845

Parent Item: D350-636-012



Parent Item Name: Skidub RH

Start Date: 11/16/2010



Required Date: 11/30/2010

Start Qty: 1.00



Required Qty: 1.00

AN3C6A Purchased No 230 Each 245.0000 4 4  
  
 BOLT  10/12/07



Location	Loc Qty	Loc Code
ST351	245	
111982	245	

AN6C44A Purchased No 230 Each 119.0000 4 4  
  
 BOLT  10/12/07

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST344	117	
111649	2	
114653	1	
114941	64	
115936	50	

AN8C35A Purchased No 230 Each 54.0000 1 1  
  
 BOLT  10/12/07

Location	Loc Qty	Loc Code
ST346	54	
114442	5	
115188	22	
115960	27	

AN960C10L NAS1149C0332 Purchased No 230 Each 25.0000 38 38  
  
 washer  10/12/07

Location	Loc Qty	Loc Code
ST245	25	
107534	25	

1115832 X38

Tuesday, November 16, 2010 1:29:02 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Work Order ID: 63845

Parent Item: D350-636-012

Parent Item Name: Skidtube LH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230

Each

0.0000

1

1



X NAS 1149C08332R/M114915



x1 11/10/12/07

WASHER

D2745

Manufactured No

230

Each

265.0000

8

8



11/10/10/07

Bushing

## Location

## Loc Qty

## Loc Code

ST023

265

52311

5

59112

4

61203

44

61988

104

63315

108

x1

11/10/10/07

D3488-042

Manufactured No

230

Each

24.0000

1

1



11/10/12/07

Blade Fitting Assembly, RH

## Location

## Loc Qty

## Loc Code

FP008

15

59643

5

62003

10

FP18

9

61690

9

x1

D3492-041

Manufactured No

230

Each

76.0000

8

8



11/10/12/07

Plug Assembly

## Location

## Loc Qty

## Loc Code

FP013

76

59114

1

61987

14

62210

61

x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Work Order ID: 63845

Parent Item: D350-636-012

Parent Item Name: Skidtur RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

230

Each

85.0000

8

8



Plug Assembly



10/12/07

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

83

59117

1

59190

4

62663

78

V8

D3535-25

Manufactured No

230

Each

21.0000

1

1



Wearshoe



10/12/07

Location

Loc Qty

Loc Code

FP18

21

62033

7

62233

14

V1

D3536-25

Manufactured No

230

Each

4.0000

1

1



Gasket



10/12/07

Location

Loc Qty

Loc Code

FP12

4

61707

4

V1

D3537-1

Manufactured No

230

Each

27.0000

3

3



Wearpad



10/12/07

Location

Loc Qty

Loc Code

FP017

27

62661

9

63313

18

B63545

X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Page 5

Work Order ID: 63845

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

281.0000

8

8



Washer



10/12/07

Location

Loc Qty

Loc Code

ST072

281

60755

81

63647

200

x8

D3672-1

Manufactured No

230

Each

667.0000

4

4



Phenolic Washer



10/12/07

Location

Loc Qty

Loc Code

ST077

667

42329

10

52505

657

x4

D3791-1

Manufactured No

230

Each

19.0000

1

1



Wearplate



10/12/07

Location

Loc Qty

Loc Code

FP17

19

61702

7

62239

12

x1

D3793-1

Manufactured No

230

Each

16.0000

1

1



Wearshoe



10/12/07

Location

Loc Qty

Loc Code

FP18

16

59151

1

59630

1

61244

1

61710

13

x1

Tuesday, November 16, 2010 1:29:02 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Page 6

Work Order ID: 63845

Parent Item: D350-636-012

Parent Item Name: Skidtool RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

13.0000

1

1



Wearshoe



10/12/07

Location

Loc Qty

Loc Code

FP18

12

61711

12

FP19

1

57947

1

YI

D3794-1

Manufactured No

230

Each

20.0000

1

1



Gasket



10/12/07

Location

Loc Qty

Loc Code

FP010

20

61704

20

YI

D3794-3

Manufactured No

230

Each

25.0000

1

1



Gasket



10/12/07

Location

Loc Qty

Loc Code

FP10

24

60826

1

61712

23

YI

FP18

1

59153

1

MS21043-6

Purchased No

230

Each

618.0000

4

4



NUT



10/12/07

Location

Loc Qty

Loc Code

ST301

618

112314

618

YI

Tuesday, November 16, 2010 1:29:02 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Work Order ID: 63845

Parent Item: D350-636-012

Parent Item Name: Skidtool RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

87.0000

1

1



NUT



10/12/07

Location

Loc Qty

Loc Code

ST303

87

113845

5

114934

3

115594

29

115884

50

NAS1611-010

Purchased

No

230

Each

309.0000

8

8



O-RING



10/12/07 PTO

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

NAS1611-013

Purchased

No

230

Each

228.0000

8

8



O-RING



10/12/07

Location

Loc Qty

Loc Code

FP

228

115460

100

115589

28

115812

100

10/12/07

W/O: 63845		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/07	230	Replace NAS 1611-010 "O" rings for DZ594-3/ M61762 "O" rings	JH	10/12/07	x 8		S 10/12/08

Part No: D350-636-012 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Page 8

Work Order ID: 63845

Parent Item: D350-636-012


Parent Item Name: Skidube RH


Start Date: 11/16/2010

Required Date: 11/30/2010


Start Qty: 1.00


Required Qty: 1.00

AN8C21A Purchased No 250 Each 45.0000 2  10/12/7 SP


 BOLT


Location	Loc Qty	Loc Code
ST345	45	
113558	1	
114653	4	
115723	40	

AN960JD816 Purchased No 250 Each 123.0000 2  10/12/7 SP


 1/2" washer, Alum


Location	Loc Qty	Loc Code
ST348	123	
106043	123	

D2741 Manufactured No 250 Each 25.0000 1  10/12/7 SP

 Blade, 350 Skidtube

Location	Loc Qty	Loc Code
ST466	25	
60210	25	

D3493-1 Manufactured No 250 Each 36.0000 2  10/12/7 SP

 Washer

Location	Loc Qty	Loc Code
ST062	36	
61672	36	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Page 9

Work Order ID: 63845

Parent Item: D350-636-012

Parent Item Name: Skidtool RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250 Each

47.0000

2



Spacer

Location

Loc Qty

Loc Code

ST065

47

61673

5

62218

42

D3672-13

Purchased No

250 Each

792.0000

2



Phenolic Washer

*no longer in list*  
*8/12/08*

Location

Loc Qty

Loc Code

ST077

792

54363

792

MS21083C8

Purchased No

250 Each

87.0000

1



NUT

Location

Loc Qty

Loc Code

ST303

87

113845

5

114934

3

115594

29

115884

50

D2600-3-BENT

Manufactured No

110 Each

13.0000

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

13

61634

4

62594

8

62764

1

*BB 10/11/23*

Tuesday, November 16, 2010 1:29:02 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Work Order ID: 63845

Parent Item: D350-636-012

Parent Item Name: Skinube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

39.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

6

59198

6

ST

33

62715

33

1 BE 10/11/23

D2739

Manufactured No

160

Each

12.0000

1

1



3501 Beam

Location

Loc Qty

Loc Code

LG

12

62563

8

62688

4

1 BE 10/11/24

D2743

Manufactured No

160

Each

150.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

150

50281

10

57953

2

59111

31

61844

107

4 BE 10/11/25

D3490-3

Manufactured No

160

Each

39.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

39

60294

1

62668

38

4 BE 10/11/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, November 16, 2010 1:29:02 PM

Page 11

Work Order ID: 63845

Parent Item: D350-636-012

Parent Item Name: Skidube RH



Star Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured

No

160

Each

95.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

95

59424

3

61217

2

62450

90

4

BE 10/11/25

Tuesday, November 16, 2010 1:29:02 PM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

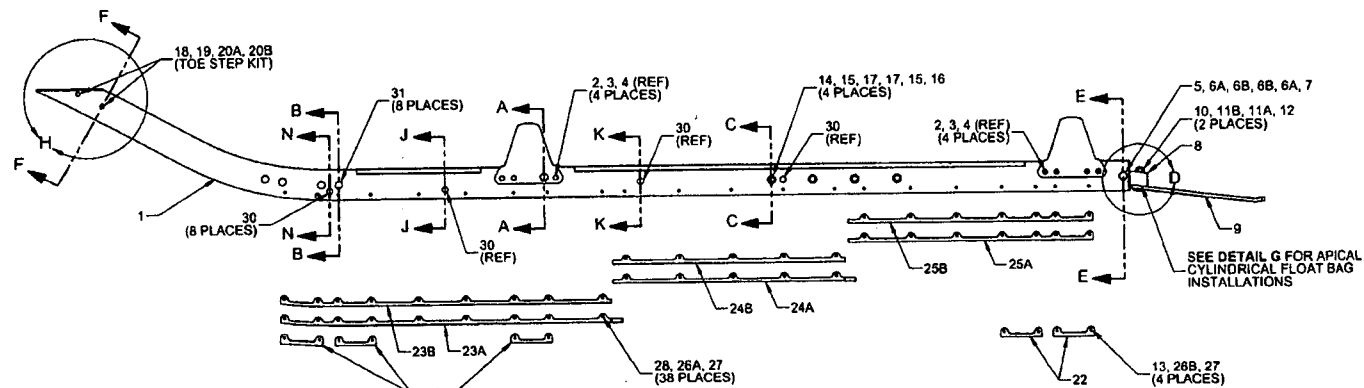
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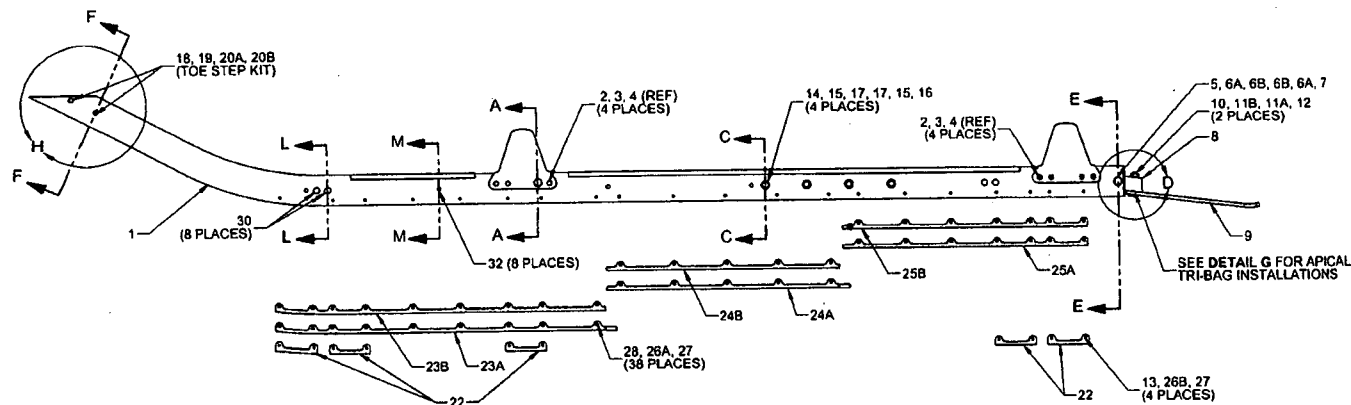
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68845  
2/10/11



D350-636-011/-012 ASSEMBLY  
(Aerazur / Apical Cylindrical)



D350-636-013/-014 ASSEMBLY  
(Aircruiser / Apical Tri-Bag)

Figure 1: D350-636-011/-012/-013/-014 SKIDTUBE ASSEMBLY AT CHG 003

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Revision: H

Date: 10.07.26

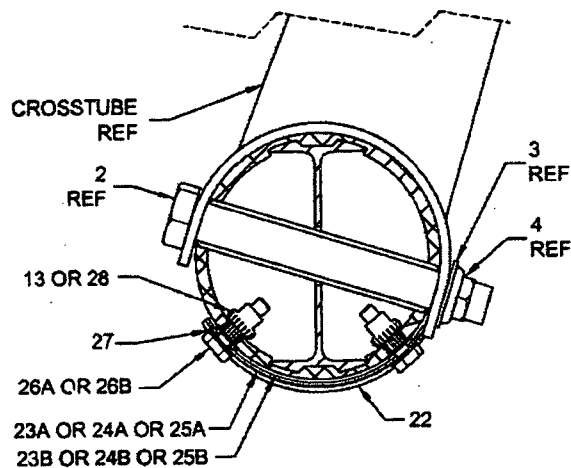
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

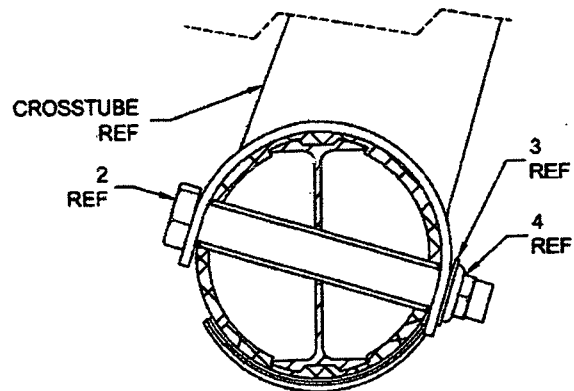
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



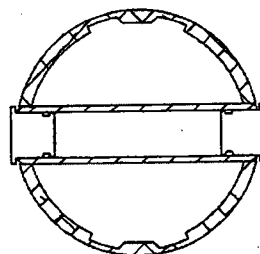
**SECTION A-A**

(D350-636-011/-012/-013/-014 SKIDTUBES  
AT CHG 003 ONLY)



**SECTION P-P**

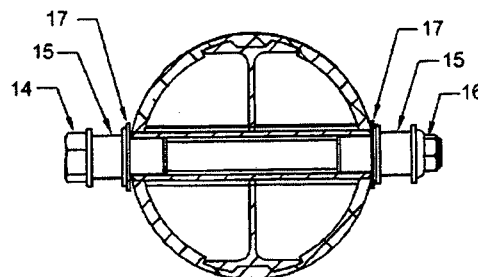
(D350-636-011/-012/-013/-014 SKIDTUBES  
AT CHG 004 OR SUBSEQUENT)



30 (SECTION J-J AND K-K AND L-L)  
OR 31 (SECTION B-B)  
OR 32 (SECTION M-M)  
(BOTH SIDES)

**SECTION B-B**

(SECTION J-J, K-K, L-L AND M-M SIMILAR)  
8 PL PER SKIDTUBE



**SECTION C-C**

4 PL PER SKIDTUBE

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Revision: H

Date: 10.07.26

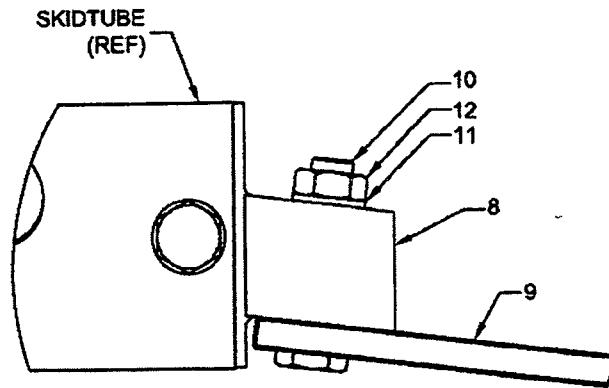
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

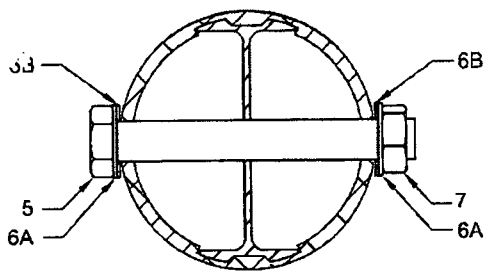
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

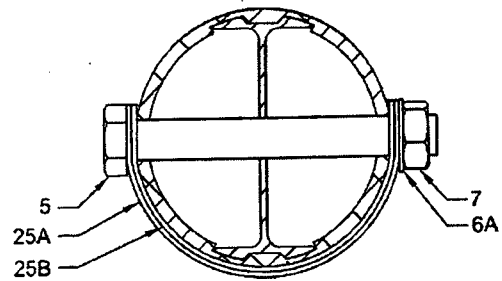
**NOTE:** Date & initial all entries



**DETAIL D**  
1 PL PER SKIDTUBE

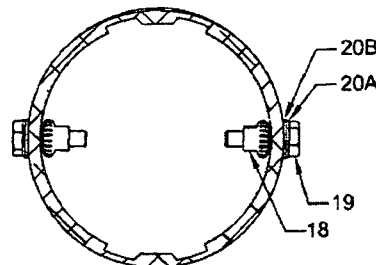


**SECTION E-E**  
(D350-636-011/-012/-013/-014 SKIDTUBES  
AT CHG 003 ONLY)



**SECTION Q-Q**  
(D350-636-011/-012/-013/-014 SKIDTUBES  
AT CHG 004 OR SUBSEQUENT)

*Handwritten note:*  
20 PL PER SKIDTUBE



**SECTION F-F**  
2 PL PER SKIDTUBE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

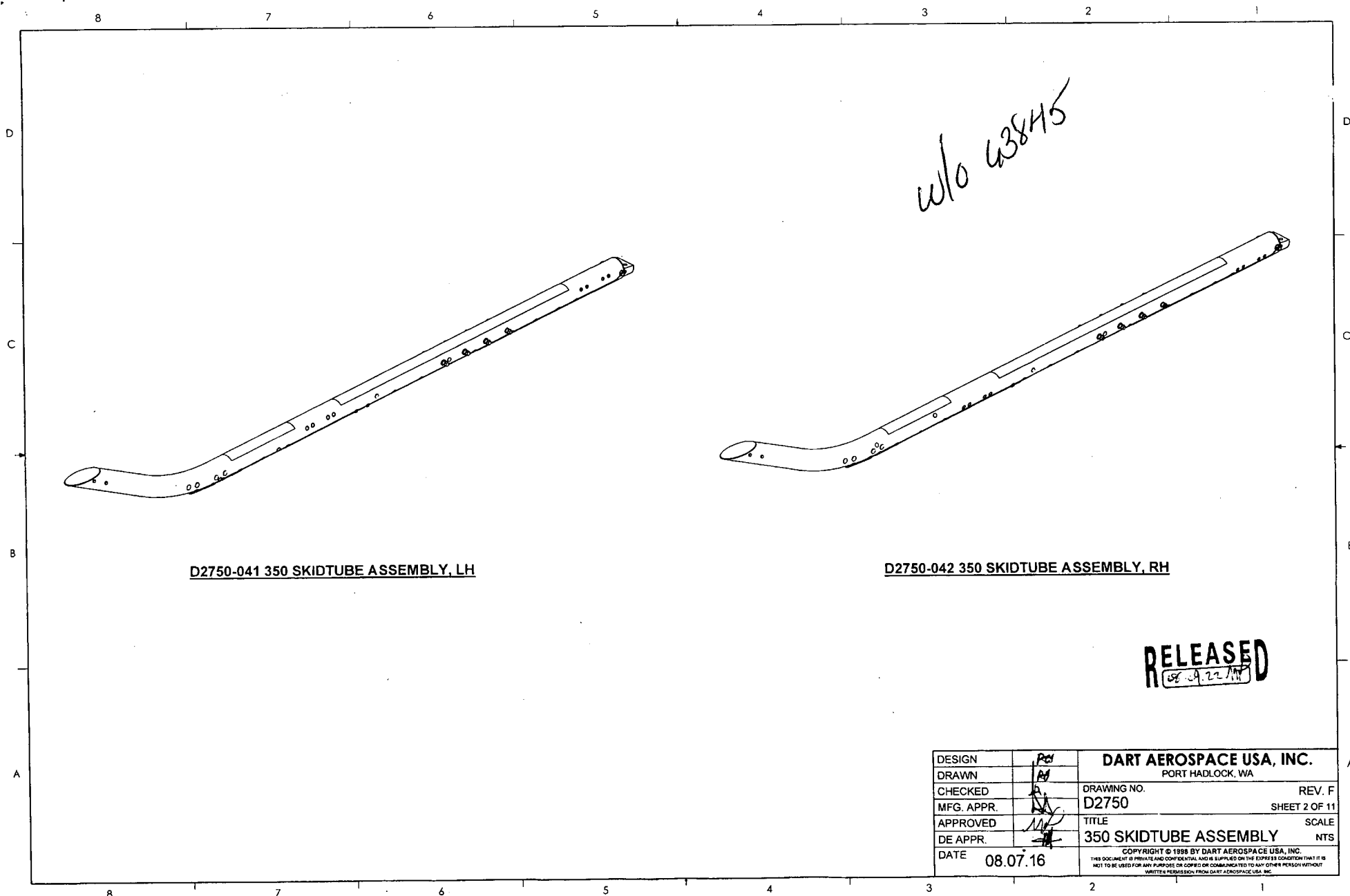
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63845  
BJ 10-11-18

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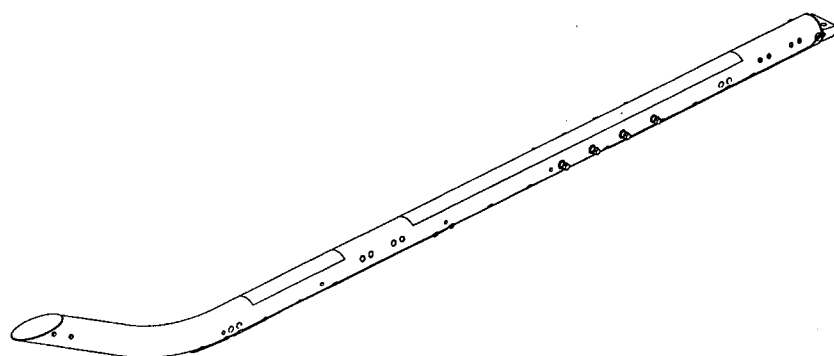
# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

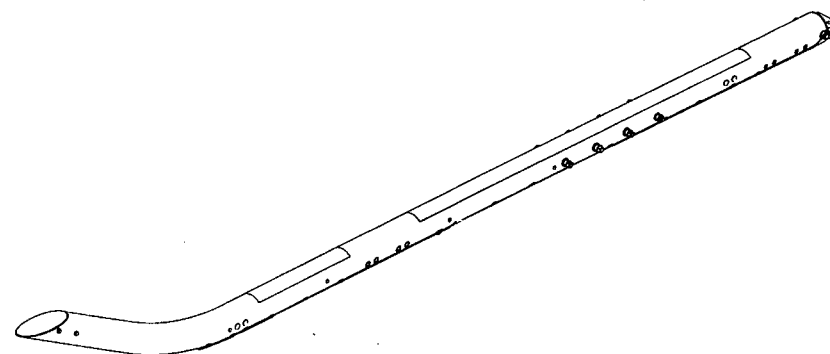
F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F SHEET 1 OF 11	
TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS	
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w/c 63845



D2750-043 350 SKIDTUBE ASSEMBLY, LH

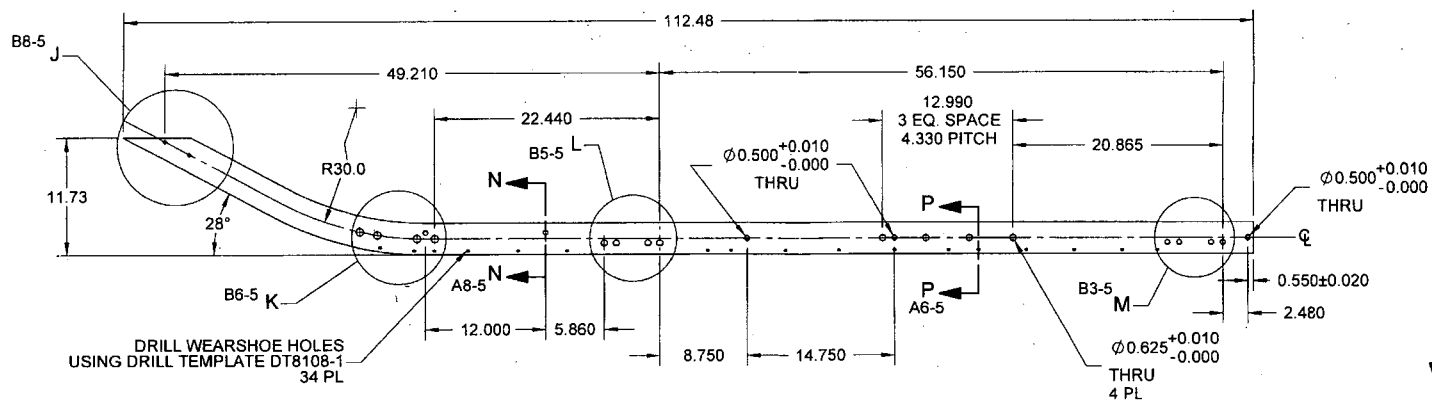


D2750-044 350 SKIDTUBE ASSEMBLY, RH

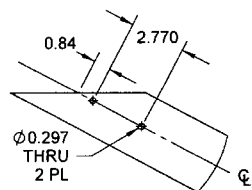
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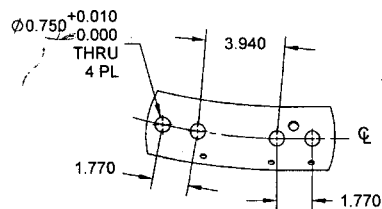




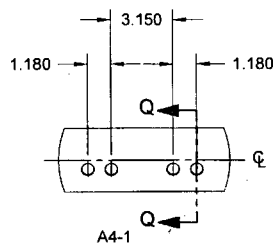
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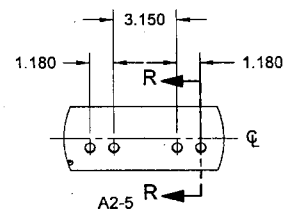
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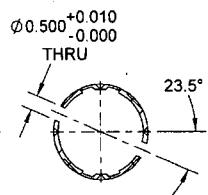
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SCALE 2X



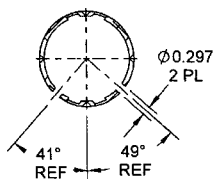
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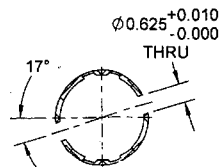
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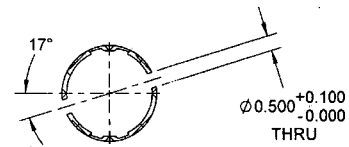
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SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL

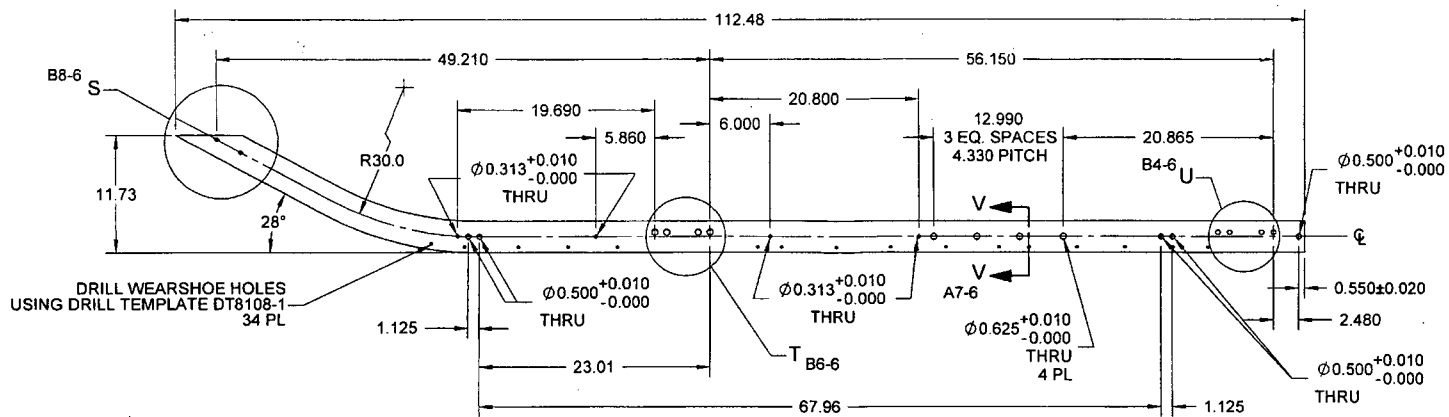


**SECTION R-R**  
SCALE 3X, 4 PL

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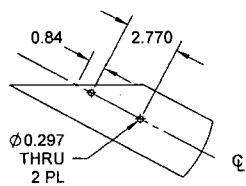
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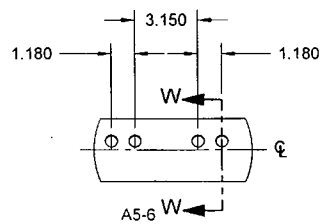


*w/b 63545*

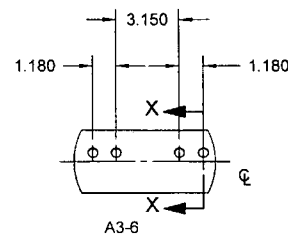
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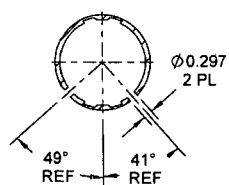
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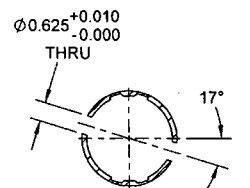
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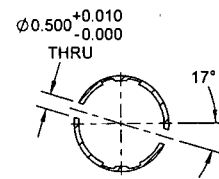
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



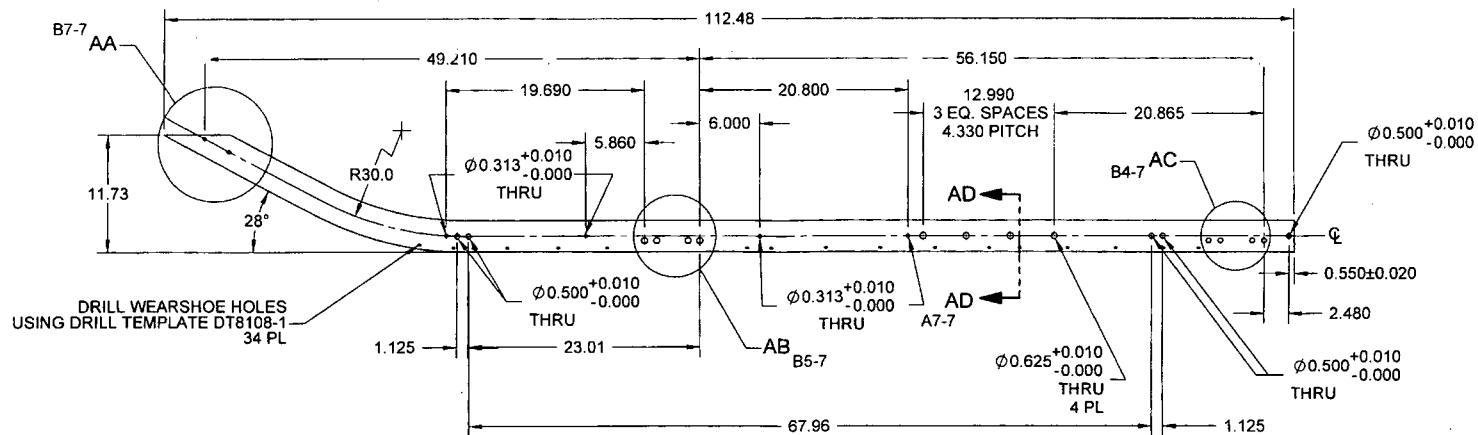
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08-12-11

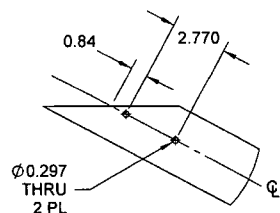
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APPROVED		SHEET 6 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	<b>08.07.16</b>	SCALE <b>NTS</b>

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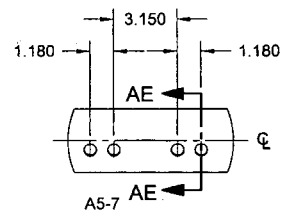
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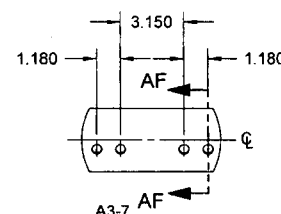
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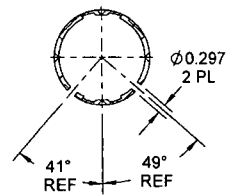
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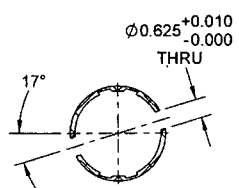
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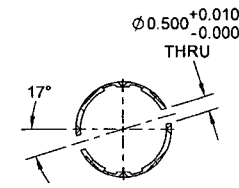
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**SECTION AD-AD**  
SCALE 3X, 17 PL



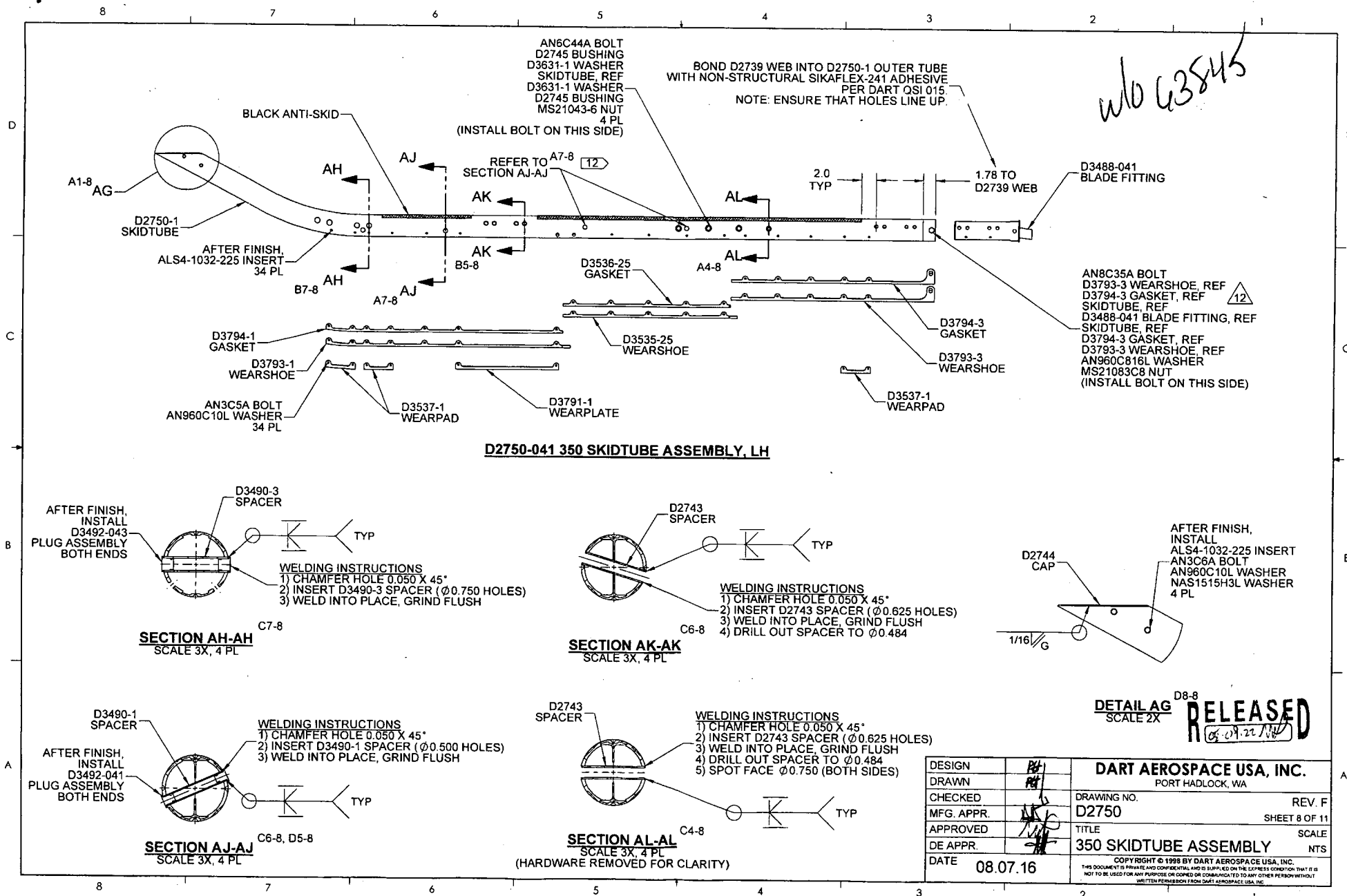
**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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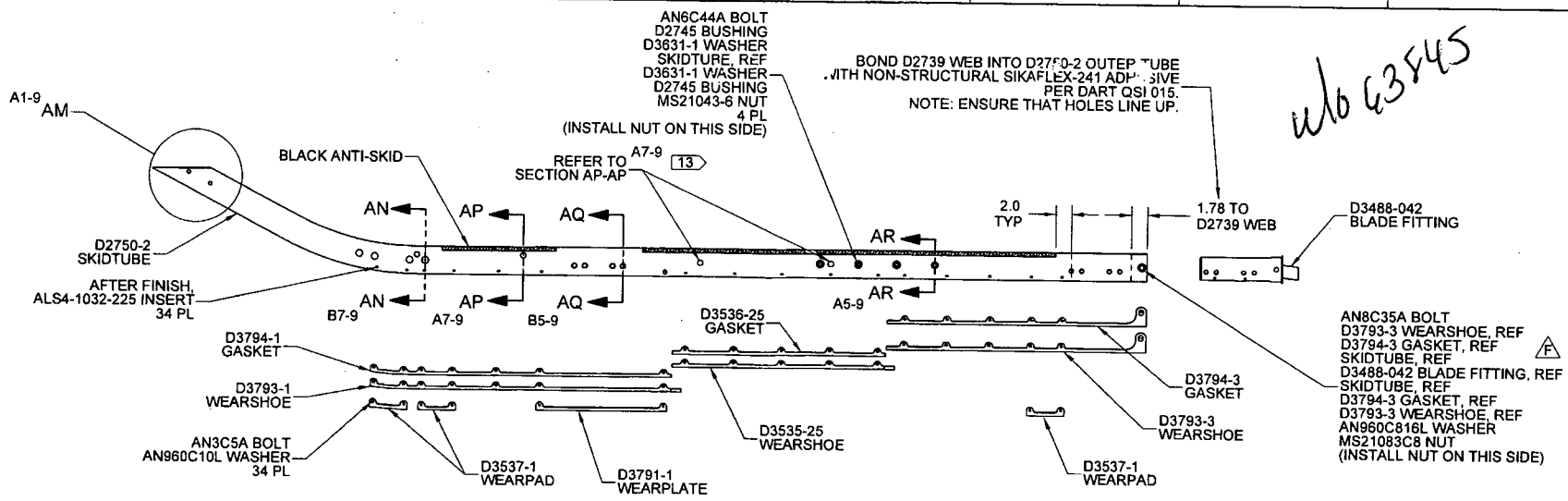


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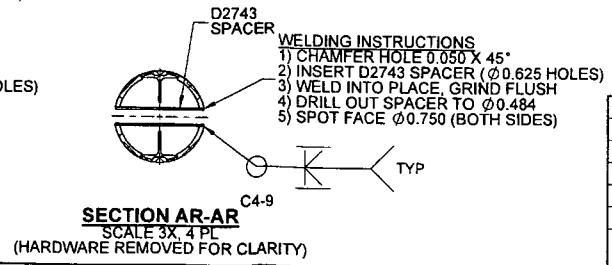
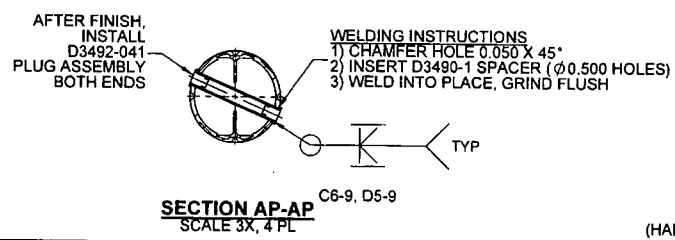
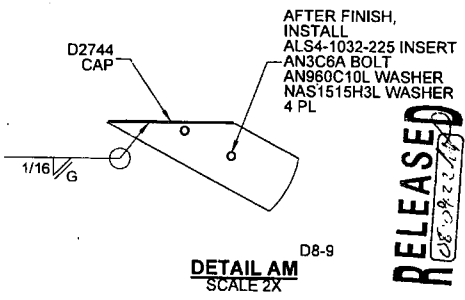
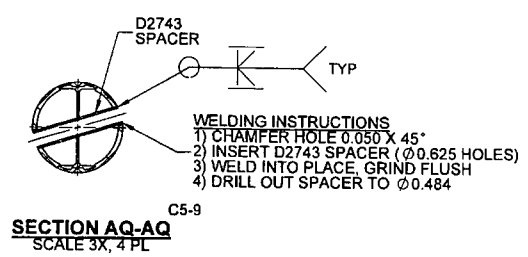
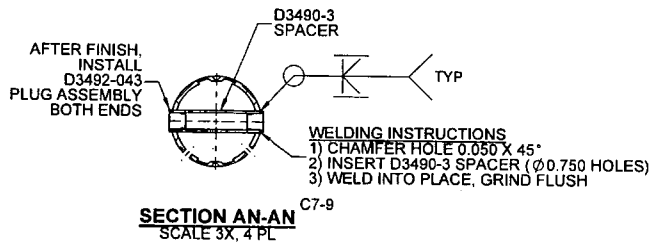


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Wb 63545

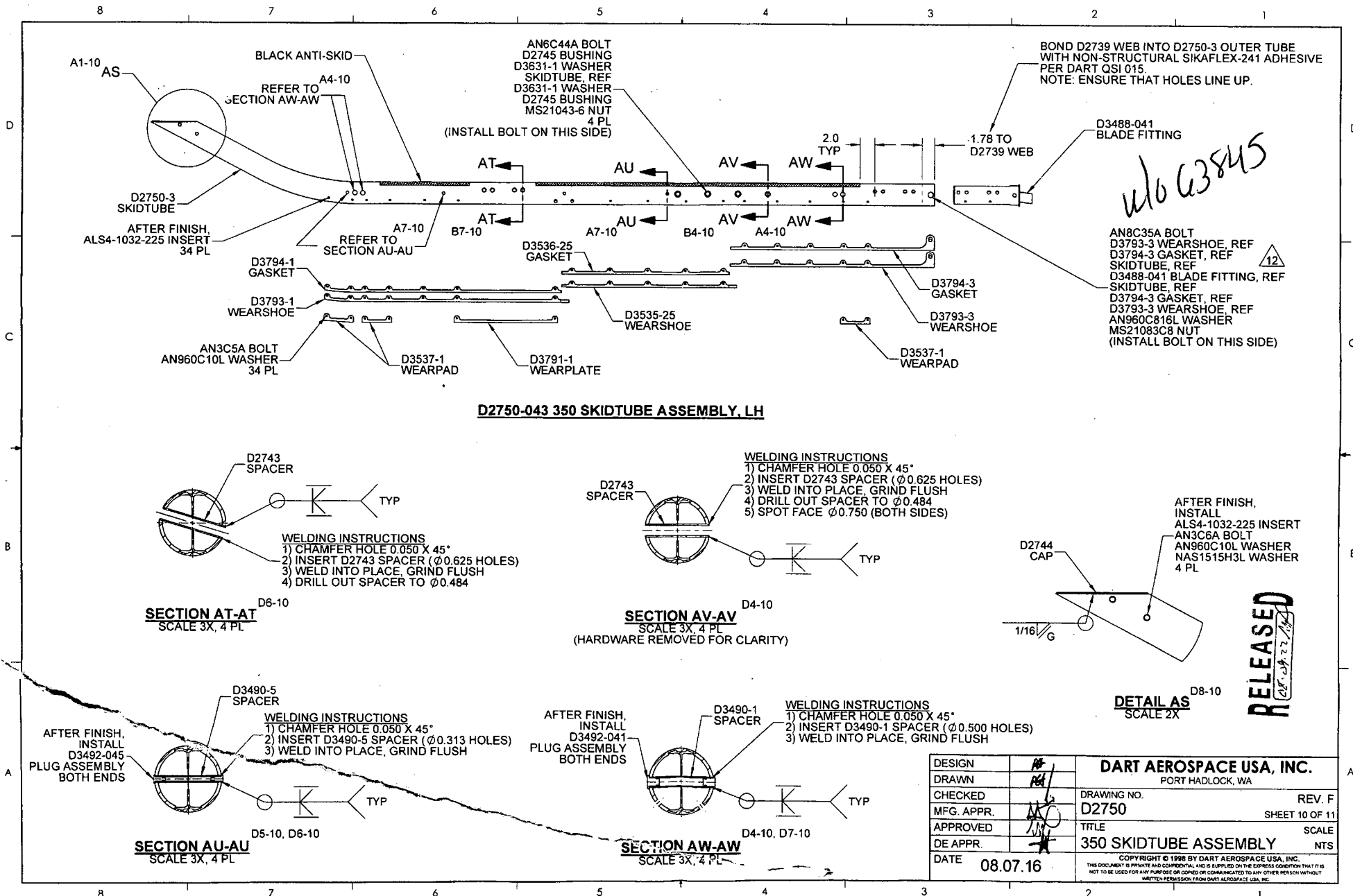


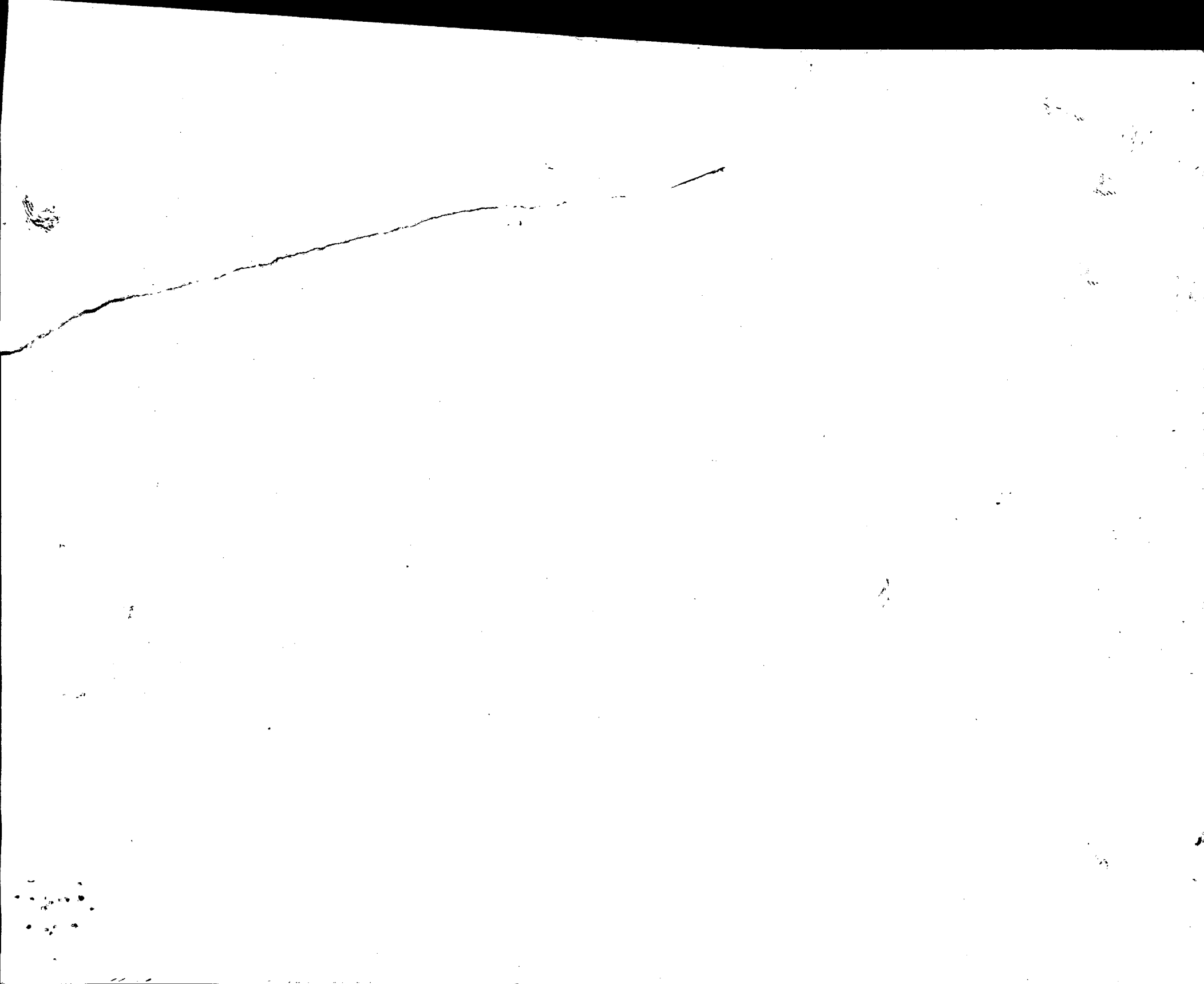
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



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08-09-2017





NO. 239

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 61946 61914  
Part number: D350.636.012  
Description: 350 skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier P.D. Day Date of Test Coupon 10.09.30

Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld